












Thursday, 4/12/2007 8:20:53 AM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 204/205 GHW MODIFICATION KIT
Job Number : 31649	
Estimate Number : 10013	
P.O. Number : N/A	Part Number : D205641011
This Issue : 4/12/2007 S.O. No. : N/A	Drawing Number : D205-641 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 28086	Material : N/A
Written By : _____	Due Date : 4/12/2007 Qty: 10 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:J Removed Manufacturing 05-10-25 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	DC DOCUMENT CONTROL
 	
Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP d205-641-011 CHG001 07.04.13 (10)	
2.0	PACKAGING 1 PACKAGING RESOURCE #1
 	
Comment: PACKAGING RESOURCE #1 Pick: Packing Kit	
3.0	D2570 Bushing
 	
Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s) Pick: Qty Part Number Description Batch 8 D2570 Bushing B31224 (24) ✓	
4.0	D27361 Lug Assembly
 	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2736-1 Bracket B29783 (6) ✓ B31045 (4) ✓	
5.0	D27363 Lug Assembly
 	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2736-3 Bracket B30053 ✓ 7/4/19 SQ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 07/04/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 204/205 GHW MODIFICATION KIT

Job Number: 31649

Part Number: D205641011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-46A Bolt

M102985 ✓

✓

7.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut

M103914 ✓

✓

(10) 7/4/20 SFD

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/4/20 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-641-017

Location: _____

REV C

07/4/20 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/20

Job Completion



07/04/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

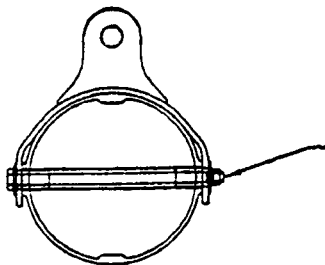
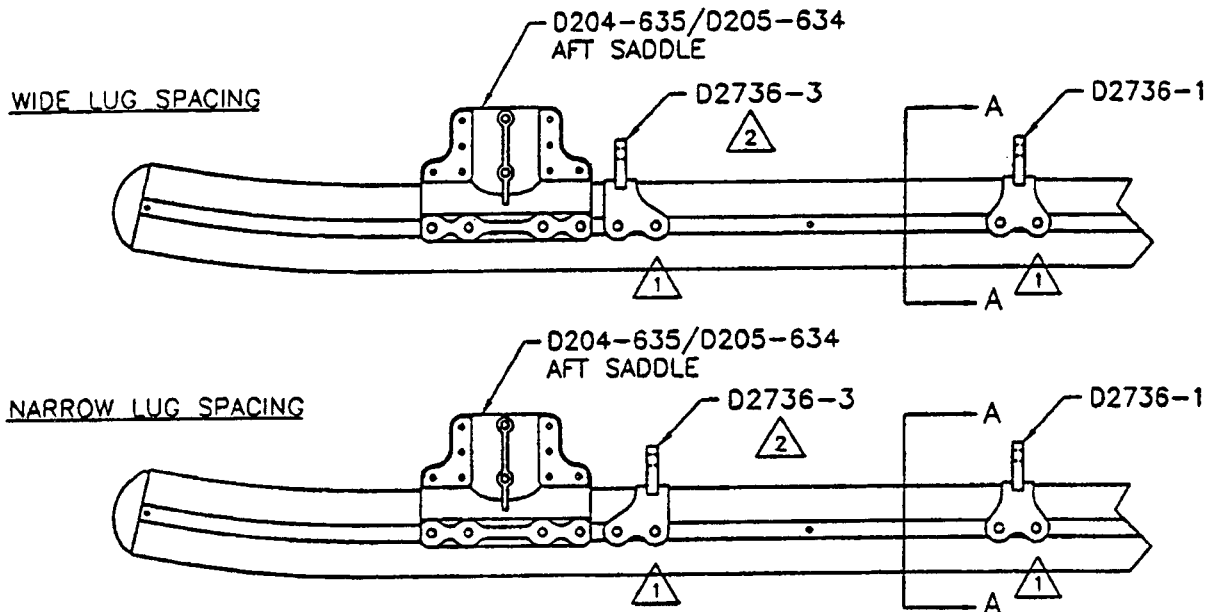
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D205-641	REV. C SHEET 1 OF 1
DATE 97.12.17		TITLE GND HANDLING WHEEL (GHW) INST.	SCALE NTS
A	96.12.04	NEW ISSUE	
B	97.06.30	ADD MECHANICAL LOCK	
C	97.12.17	RE-DESIGN TO 2 SEPARATE LUGS	

TO ADAPT STANDARD BELL GROUND HANDLING WHEELS TO DART 204/205/212/412 SKIDTUBES, INSTALL THE D2736-1 & D2736-3 LUG ASSEMBLIES AS SHOWN BELOW.



VIEW A-A

AN4-46A BOLT (1)
D2570 BUSHING (2)
MS21042L4 NUT (1)
(4 PLACES)

- 1 THESE HOLES DO NOT EXIST IF AN EARLY MODEL SKIDTUBE IS BEING RETRO-FITTED. DRILL $\phi 0.438$ HOLE @ 1.750 FROM CENTER OF PREVIOUS HOLE, DE-BURR, AND TOUCH-UP WITH ZINC CHROMATE PRIMER.
- 2 D2736-3 LUG MAY BE INSTALLED IN EITHER ORIENTATION TO PROVIDE THE WIDE OR NARROW LUG SPACING AS REQUIRED BY DIFFERENT TYPES OF GROUND HANDLING WHEELS.

D205-641 GROUND HANDLING WHEEL ADAPTORS MAY REMAIN INSTALLED DURING FLIGHT ON D205-634 & D204-635 SKIDTUBE INSTALLATIONS. IF INSTALLED THE WEIGHT AND BALANCE INFORMATION IS AS FOLLOWS:

	WEIGHT	LONG. ARM	MOMENT
205/212/412 SKIDTUBES (D205-634)	2.0 lb 0.9 kg	148.2 in 3.76 m	296 lb in 3.38 kg m
204 SKIDTUBES (D204-635)	2.0 lb 0.9 kg	135.3 in 3.44 m	271 lb in 3.10 kg m

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31649